

Date: Wednesday, 06/08/2008 2:06:55 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP HI LONG		
Job Number	: 41033			Part Number	: D32721		
Estimate Number	: 12897			Drawing Number	: D3272 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/08/2008	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 29/08/2008	Qty:	20
Previous Run	: 40855			Um:	Each		
Written By	:						
Checked & Approved By	: JLD 08.8.ao						
Comment	: Est Rev:A New Issue 07-06-09 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D2622120C	Step Extrusion		
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)				
Pick: Qty Part Number      Description      Batch 1 D2622-120      Extrusion      B40937				
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1		
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 <p>1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A</p> <p>2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.</p> <p>3-Deburr   </p>				
3.0	QC5	INSPECT WORK TO CURRENT STEP		
<b>Comment:</b> INSPECT WORK TO CURRENT STEP				
4.0	PACKAGING 1	PACKAGING RESOURCE #1		
<b>Comment:</b> PACKAGING RESOURCE #1 <p>Identify and Stock</p> <p>Location: WA </p>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP HI LONG

Job Number: 41033

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/23 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272 REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS
A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED

07 06 04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



B

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

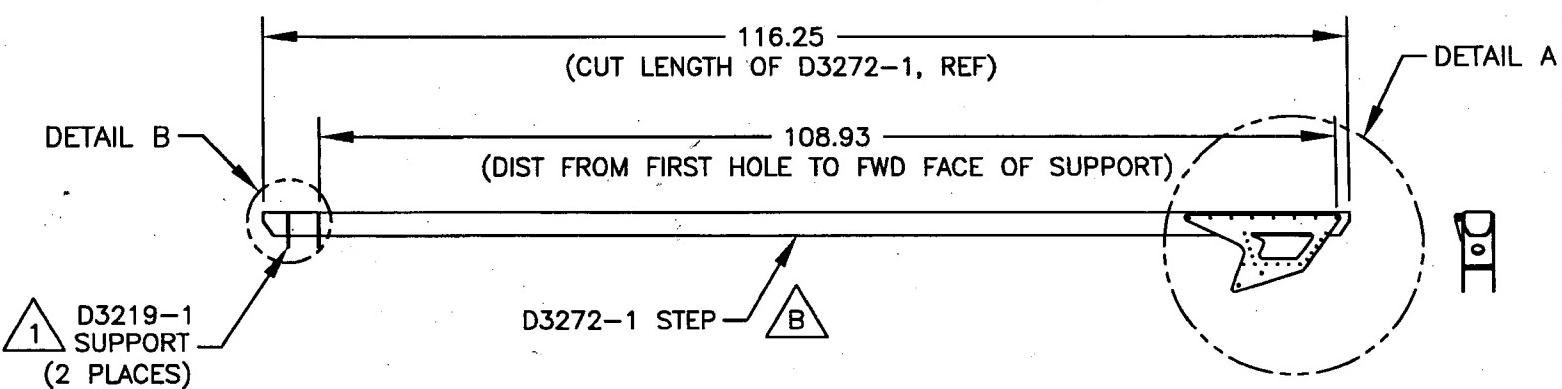
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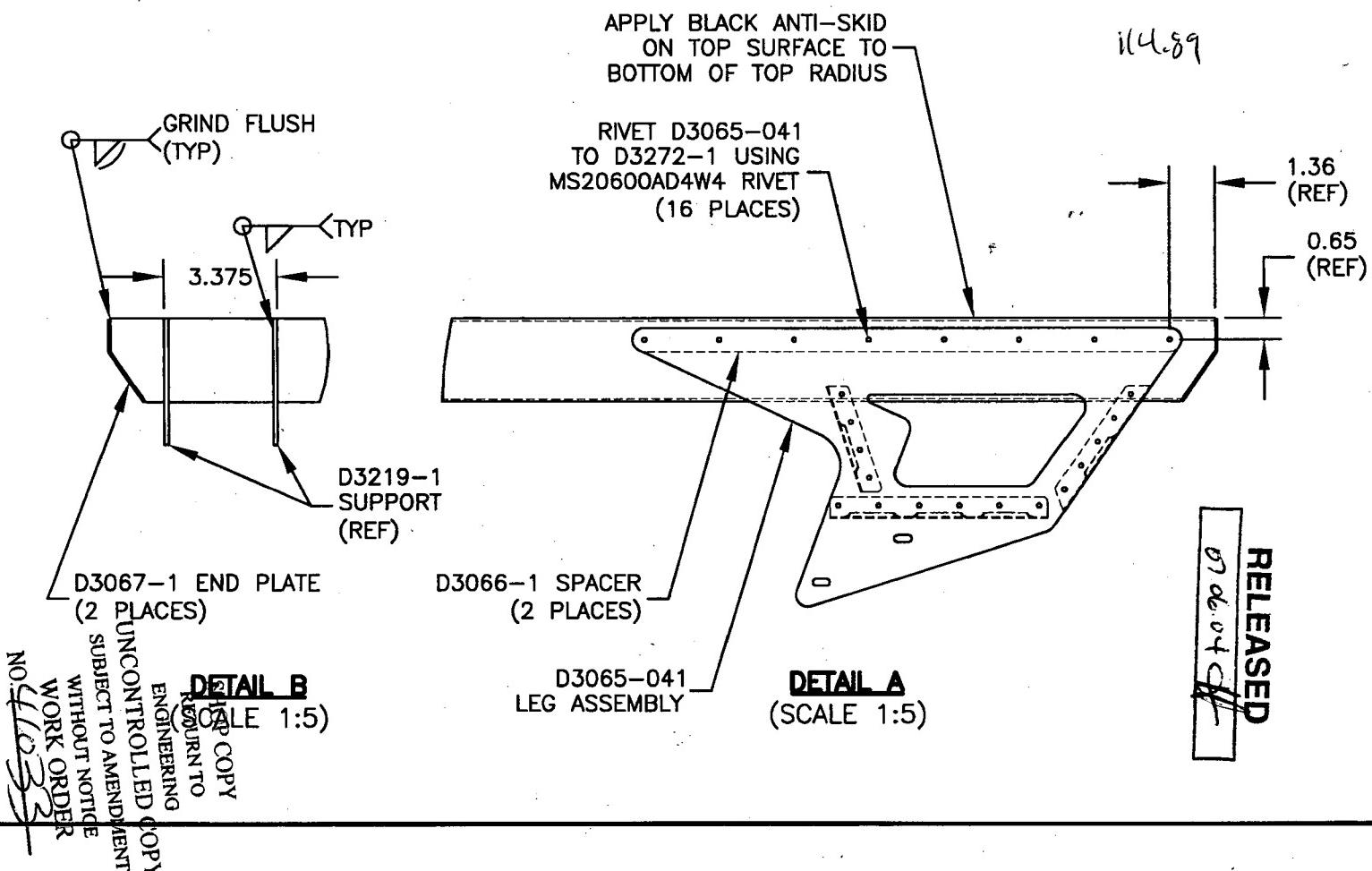
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CHECKED	APPROVED	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	DRAWING NO.
DATE	07.05.18	STEP ASSEMBLY, LH LONG
TITLE		SHEET 2 OF 3
SCALE		1:20

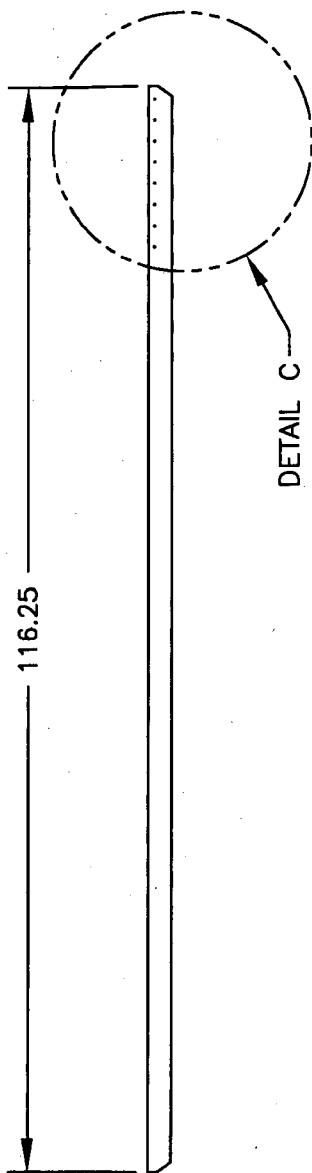


**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

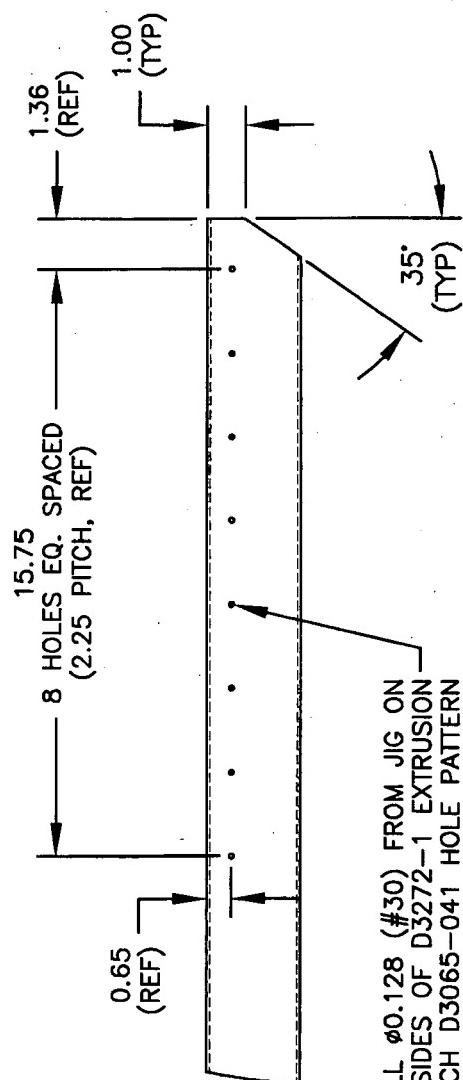


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CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



△ D3272-1 STEP  
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C  
(SCALE 1:5)

DRILL #0.128 (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

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